



Dart Aerospace Ltd.  
1270 Aberdeen St  
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K6A 1K7  
Canada

Tel (613) 632-5200

**C10-27-1**  
**Job Sheet 179893**



Part No: C10-27-1

Job Qty: 10 ea

Part Name: Lifting Plate



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/25/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-27-1 Rev. 3 IPP REV A RQ 17.09.01 VERIFIED BY DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 10 Ea  |            | 7/13/18  | 0.00      | 0.00    | Start Up Waterjet     |           | de 18/07/19 |
| 110   | Waterjet           | 10 pcs |            | 7/13/18  | 0.00      | 1.00    | Waterjet1             |           | de 18/07/19 |
| 120   | QC                 | 10 pcs |            | 7/13/18  | 0.00      | 0.00    | QC2 Waterjet-1        |           | de 18/07/19 |
| 170   | QC                 | 10 pcs |            | 7/13/18  | 0.00      | 0.00    | QC8-1                 |           | de 18/07/19 |
| 220   | Packaging          | 10 pcs |            | 7/13/18  | 0.00      | 0.00    | Packaging3            |           | de 18/07/19 |
| 230   | QC21-SA            | 10 Ea  |            | 7/13/18  | 0.00      | 0.00    | QC21                  |           | de 18/07/19 |

Part Op 110 - 1-Cut as per DWG. DWG. Rev: 3 PROG. Rev: 3 2-Deburr if necessary

DAS  
21  
9-89

AUG 01 2018

### Job BOM

| Part / Item     | Component Name                       | Quantity           | Operation             | Container |
|-----------------|--------------------------------------|--------------------|-----------------------|-----------|
| MT-HRS-P-0.3125 | Hot Rolled Steel Plate 0.3125" (44W) | 8.4000 ft (.84 ea) | 90-Start up Operation | 5001352   |

### Job Allocations

| Operation             | Component Part  | Required | Inventory | Allocated |
|-----------------------|-----------------|----------|-----------|-----------|
| 90-Start up Operation | MT-HRS-P-0.3125 | 8        | 7         | 0         |

### Part Specifications

Specifications could not be found.

Plex 6/25/18 3:25 PM Dart.lajeunesse.marie



DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

| Work Order:                      |                   | DISPOSITION                                  |               | AGAINST DEPARTMENT/PROCESS |                     |             |  |
|----------------------------------|-------------------|----------------------------------------------|---------------|----------------------------|---------------------|-------------|--|
| Part No. _____                   | Work Order: _____ | Rework                                       | Skid-tube     | Cross tube                 | Water Jet           | Engineering |  |
| NCR No. _____                    |                   | Scrap                                        | Machining     | Small Fab                  | Prod. Eng. Coord.   | Quality     |  |
|                                  |                   | Use-as-is                                    | Thermoforming | Finish                     | Rec/Store/Packaging | Other       |  |
|                                  |                   | Suspected Unapproved                         | Large Fab     |                            | Supplier            |             |  |
| Date: _____                      | Step #: _____     | MRB (QSI042) Approval                        |               |                            |                     |             |  |
| Description Work Order Deviation |                   | Completed By                                 |               |                            |                     |             |  |
|                                  |                   | Lead hand / Supervisor Approval Verification |               |                            |                     |             |  |
|                                  |                   | QC / QA Coordinator Approval                 |               |                            |                     |             |  |

**DART AEROSPACE**

Container No: S093961

Part: C10-27-1

Job No: 179893

Serial No/Batch: S093961

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 07/19/18

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| Root Cause         |              |          |              |          |          |                 |                  |         |                       |
|--------------------|--------------|----------|--------------|----------|----------|-----------------|------------------|---------|-----------------------|
| Environment        | No Re-verfi. | Operator | Offset/Setup | Supplier | Training | Use for Testing | Poor Information | Rushing | Product Improvement   |
| Design             |              |          |              |          |          |                 |                  |         | Process Improvement   |
| Doc/Data           |              |          |              |          |          |                 |                  |         | Manufacturing Process |
| Equip/Tooling      |              |          |              |          |          |                 |                  |         | Past Due              |
| Handling/Pre       |              |          |              |          |          |                 |                  |         |                       |
| Material           |              |          |              |          |          |                 |                  |         |                       |
| Internal Transport |              |          |              |          |          |                 |                  |         |                       |
| Tribal Knowledge   |              |          |              |          |          |                 |                  |         |                       |
| LOA                |              |          |              |          |          |                 |                  |         |                       |
| Substation         |              |          |              |          |          |                 |                  |         |                       |
| Past Expiry Date   |              |          |              |          |          |                 |                  |         |                       |
| Misidentified      |              |          |              |          |          |                 |                  |         |                       |

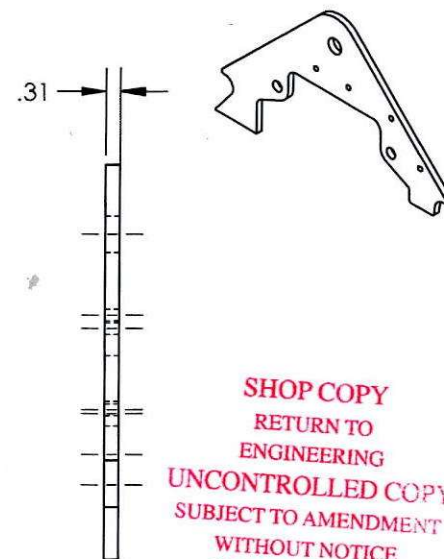
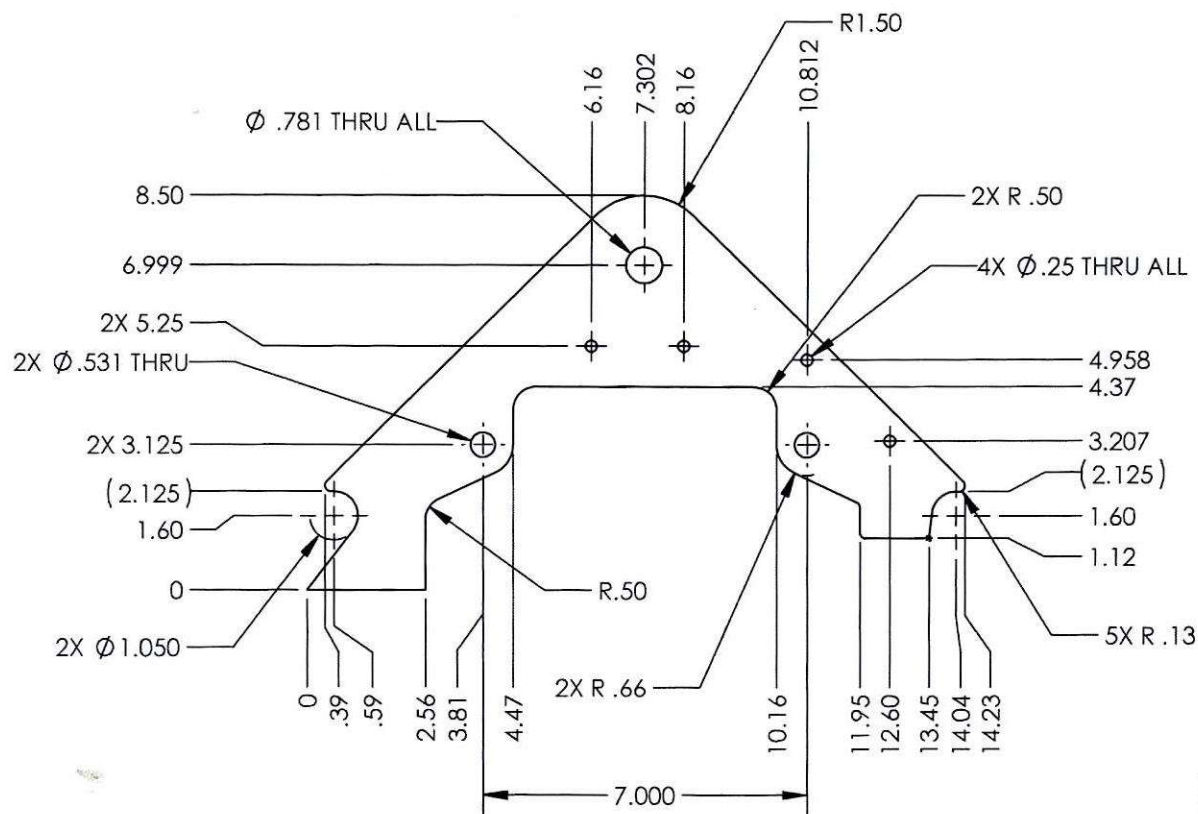
| Other            |                    |                      |                                 |                   |            |              |                       |         |                  |
|------------------|--------------------|----------------------|---------------------------------|-------------------|------------|--------------|-----------------------|---------|------------------|
| Heat Treat       | Wave/Twist in Tube | Marks/Chatter        | OTHER :                         |                   |            |              |                       |         |                  |
| Contamination    | Countersink        | Cut Too Short        | Instructions Incomplete/Unclear | Drill Holes       |            |              |                       |         |                  |
| Grain            | Weld               | Wrong Stock Pulled   | Out of Sequence                 | Off-set           | Mislabeled | Fit/Function | Misaligned/off center |         |                  |
| Positioned Wrong | Outside Dimensions | Over/Under tolerance | Part Incorrect                  | Part Lost/Missing | Part Moved | Drawing      | Finish                | Misread | Turning Sequence |





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| REVISIONS |         |                                                                                                                                                                                                                                                                                                |  | DATE | INITIAL    | APPROVED |
|-----------|---------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------|------------|----------|
| REV       | ECR     | DESCRIPTION                                                                                                                                                                                                                                                                                    |  |      |            |          |
| 2         |         | AS DRAWN BY APICAL                                                                                                                                                                                                                                                                             |  |      | 1/8/2013   | JAG      |
| 3         | 16-0161 | CH'D MAT'L WAS HR P&O IS A36/1018/1020 HR. CH'D DIM WAS Ø.760 THRU IS Ø.781 THRU ALL. WAS (.313) IS .31, WAS 4X Ø.250 THRU IS 4X Ø.25 THRU ALL. WAS 2X 5.250 IS 2X 5.25, WAS 3.812 IS 3.81, WAS 6.157 IS 6.16 WAS 8.157 IS 8.16, WAS 2X 10.812 IS 10.81, WAS 12.597 IS 12.60. ADDED DIM 7.000. |  |      | 10/12/2016 | RJC JAG  |



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WITHOUT NOTICE  
WORK ORDER  
NO. 179893 MJS  
1806-25

|                               |                                                        |
|-------------------------------|--------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>     |                                                        |
| TITLE<br><b>LIFTING PLATE</b> |                                                        |
| DWG NO.<br><b>C10-27-1</b>    | REV<br><b>3</b>                                        |
| MAT'L A36/1018/1020 HR        | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |
| HEAT TREAT                    | .XXX ± .005 FRACTIONS ± 1/8                            |
| FINISH                        | .XX ± .01 ANGLES ± 5°                                  |
| SPEC                          | .X ± .1 SURFACES = 125/                                |
| DRAWN BY: APICAL              | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R        |
| CHECKED: DUERFELDT            | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING           |
| OPPS APPR: ANDERSON           | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009       |
| QA APPR: LINDSAY              | USED ON MODEL                                          |
| APPROVED: GILBERT             |                                                        |
| SCALE 1:4                     | DATE 5/30/2002                                         |
| SHEET 1 OF 1                  |                                                        |

| ASSY QTY | ASSY QTY | B/O | Part #   | UNIT QTY | Description   | Material         | B/O INFORMATION OR SPECIFICATIONS |
|----------|----------|-----|----------|----------|---------------|------------------|-----------------------------------|
|          |          |     | C10-27-1 | 1        | LIFTING PLATE | A36/1018/1020 HR |                                   |